

Work Order ID 78208

78208

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January-02-12 10:15:25 AM

Item ID: D3965-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing, Spherical
 Start Date: 02/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3965	Rev A								

100 0.00
100
 Purchasing Memo 0.00
 Purchasing PURCHASING
 Issue P/O: 15794
 Purchase Part Number: 63215K32 or 63215K52
 Possible Supplier: McMaster
 Material release note is required

CL 10/01/05 20

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging

12/01/09 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							<i>count</i> <i>(x20)</i>
130 *130* Packaging Packaging	<i>change place</i> Identify as per dwg & Stock Location 71 Memo	0.00 0.00							<i>12/1/12</i> <i>20</i>
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/1/12</i> <i>mf</i> <i>12-01-12</i>

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Picklist Print

January-02-12 10:15:29 AM

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Work Order ID: 78208

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Parent Item: D3965-4

D3965-4

Parent Item Name: Bearing, Spherical

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K32 *63215K32* Spherical Bearing 52		Purchased	No			110	Each	0.0000	1	20	**	12/20/12 (20)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

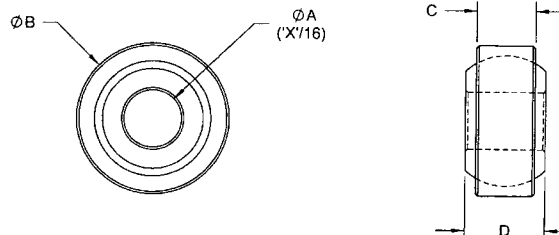
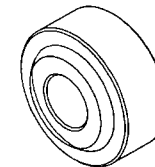
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



ENCLOSURE
SUBJECT TO WORK ORDER
WITHOUT THE
WORK ORDER
NO 38200-MCJ
12/01/02

D3965-X BEARING, SPHERICAL

WHERE 'X' IS I.D. IN 1/16" OF AN INCH
EG $\phi 1/4"$ (4/16") I.D. BEARING = D3965-4

DART P/N	SUPPLIER	SUPPLIER P/N	A	B	C	D	STATIC RADIAL LOAD CAP. lbs
D3965-3	McMASTER-CARR	63215K31	0.188	0.563	0.281	.219	3,975
D3965-4	McMASTER-CARR	63215K32 OR 63215K52	0.250	0.656	0.344	0.250	6,040
D3965-5	McMASTER-CARR	63215K53	0.313	0.750	0.375	0.281	8,750
D3965-6	McMASTER-CARR	63215K34	0.375	0.813	0.406	0.313	10,540

these dims are in the
work column.
should be reversed

RELEASED
09/08/25 MJP

NOTES:

- 1) MATERIAL: 440C STAINLESS STEEL WITH PTFE LINER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

A		NEW ISSUE		RF	09.07.09
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	RF	DRAWING NO.	REV. A		
MFG. APPR.	RF	D3965	SHEET 1 OF 1		
APPROVED	RF	TITLE	SCALE		
DE APPR.	RF	BEARING, SPHERICAL	NTS		
DATE		09.07.09			
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15794

Purchase Order Date 1/05/12

PO Print Date 1/05/12

Page Number 1 of 1

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone

330 995 5500

Vendor Fax

330 995 9600

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

64 12/01/05

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	63215K52	Bearing Spherical	1/09/12 Yes	20.00 Each	FedEx/PI collect	\$15.6200	\$312.40
		Special Inst:	AS PER DWG D3965 REV. A B78208				
2		7509A82 1300L SCOTCH- WELD	1/09/12 Yes	8.00 Each	FedEx PI collect	\$36.2500	\$290.00

Deliver To: SYLVIE

PO Total:

\$602.40

Change Nbr:

1

Change Date:

1/05/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Purchase Order
PO15794

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200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

McMaster-Carr Number
7591337-01

01/05/2012

Line	Description	Ordered	Shipped	A12		
1	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick	20 Each	20	3 - 483 - 02	07 - 01 K52	20 EA 1
	Unit Price:	\$15.62				
	Extended Price:	\$312.40				
2	7509A82 3M Scotch-Weld Rubber and Gasket Adhesive, No. 1300L, 1-Quart Can	8 Each	5	1 - 658		2 HZ-D
	Unit Price:	\$43.78				
	Extended Price:	\$218.90				

Expected to ship

2 **7509A82** 3M Scotch-Weld Rubber and Gasket Adhesive, No. 1300L, 1-Quart Can 8 Each 3 to ship by 01/12

Charges for this shipment

Merchandise Amount: \$531.30
Sales Tax: \$26.57
Total: \$557.87

Dart Aerospace Ltd

EXP
HZ-D



11 lbs
2 lines

Sm
18x8x6

FW1WBP33
01/05/2012
13:58/14:22
653
Cycle 46

SS-R-0707

